

Date: Monday, 12/01/2009 2:37:23 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: COVER
Job Number	: 44671		
Estimate Number	: 12963		
P.O. Number	:	Part Number	: D36414
This Issue	: 12/01/2009 S.O. No. :	Drawing Number	: D3641 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 43233	Material	:
Written By	:	Due Date	: 02/02/2009 Qty: 6 Um: Each
Checked & Approved By	: <u>JUL 09.01.13</u>		
Comment	: Est Rev:A New Issue 07-07-20 JLM Verified By:EC Est Rev:B ECN 1050 rev.b as per dwg 08-01-10 DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S032	6061-T6 Sheet 0.032"
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MAT NOT PULLED



Comment: Qty.: 0.8244 sf(s)/Unit Total: 4.9461 sf(s)

M6061-T6 .032" THK sheet

Batch: 110068 LB 9-2-10

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3641

Dwg Rev: BProg Rev: B

LB 9-2-10

2-Deburr if necessary

LB 9-2-10

M-1 09/02/10

(6)

(6x)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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LB 9-2-10



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 09/02/10

(x6)

(P10)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Form as per Dwg D3641-1

S 09/02/10

09/02/10

(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3641-4 PAR #: N/A Fault Category: Prod / Pre-assy metal & Small NCR: Yes No DQA: D Date: 05/03/20
 Resolution: Revised process Disposition: Scrap QA: N/C Closed: D Date: 05/03/20

NCR: <u>44671</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/03/17</u>	<u>5</u>	<u>1 piece crack.</u> <u>Die was too small</u> <u>change procedure to</u> <u>make the parts</u> <u>R.C: Incorrect radius used on</u> <u>offset die.</u>	<u>[Signature]</u> <u>05/04/2</u>	<u>Scrap a destroy</u> <u>Qty 1</u>	<u>[Signature]</u> <u>09/03/17</u>	<u>[Signature]</u> <u>02/09/17</u>	<u>[Signature]</u> <u>05/04/2</u>	<u>[Signature]</u> <u>09/03/17</u>

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:37:23 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER

Job Number: 44671

Part Number: D36414

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/03/17 (X5)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FD 09/03/17 (5)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-17

(X5)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock-
Location: _____

10/3/18 (8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/18

Job Completion



10/03/18

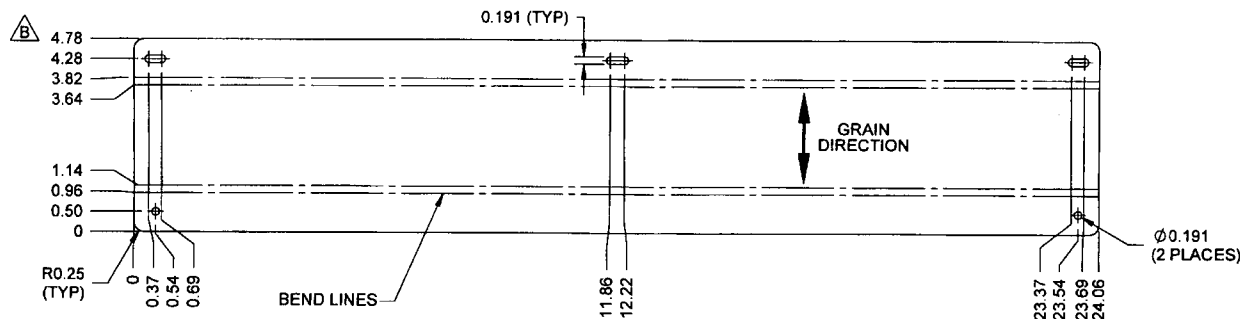
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

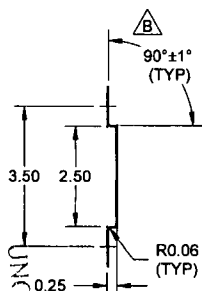
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3641-1F FLAT PATTERN



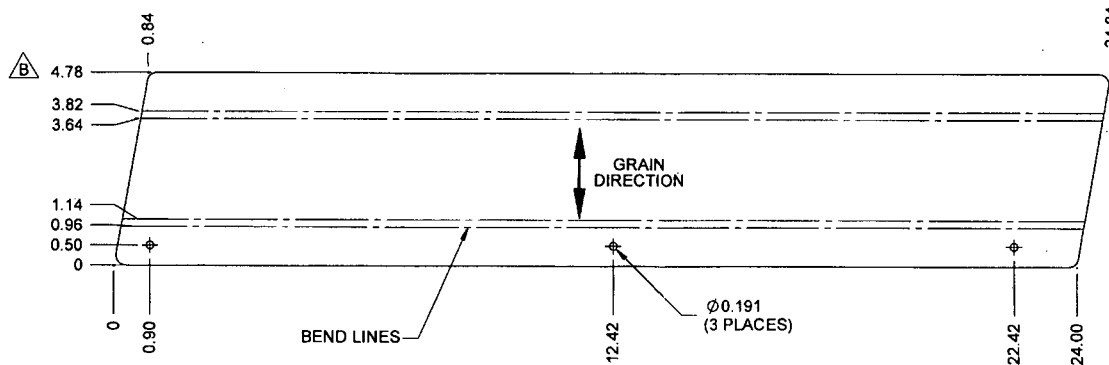
**D3641-1 COVER
(REPLACES GENEVA P/N G10606-3/-6)**

NO WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHIP COPY

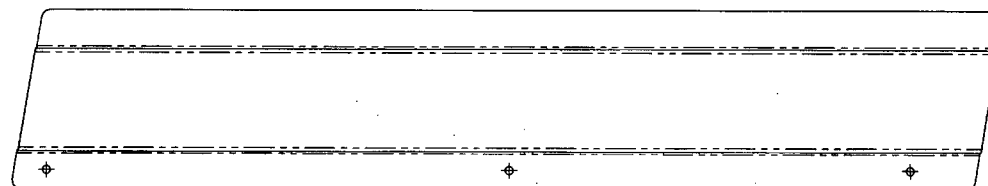
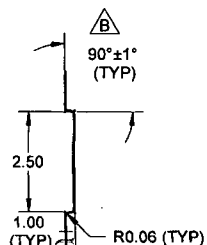
- NOTES:
- 1) MATERIAL: 5052-H32 ALUMINUM 0.032 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.032)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.35 lbs

RELEASED
07.10.16

B	UPDATE PROFILE TO MATCH TOOLING; GENERAL UPDATE	LE	07.10.16
A	NEW ISSUE; REPLACES G10606	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	LE	PORT HADLOCK, WA	
CHECKED	AB	DRAWING NO.	REV.
MFG. APPR.	IS	D3641	SHEET 1 OF 2
APPROVED	TH	TITLE	SCALE
DE APPR.	TH	COVER	1
DATE	07.10.16	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT IT'S WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3641-3F FLAT PATTERN



D3641-3 COVER
(REPLACES GENEVA P/N G10606-5)
D3641-4 OPPOSITE
(REPLACES GENEVA P/N G10606-4)

RELEASED
07.11.14

- NOTES:**
- 1) MATERIAL: 5052-H32 ALUMINUM 0.032 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.032)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-3/-4" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.36 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	LE	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	BP	D3641	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	TH	COVER	1:
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NO. 421071
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY